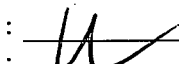
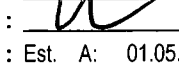


Date: Thursday, 9/11/2008 8:36:44 AM
User: Chantal Lavoie

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE BILLET
Job Number :	41960	Part Number :	D6101007
Estimate Number :	10035	Drawing Number :	D6101 REV A
P.O. Number :		Project Number :	N/A
This Issue :	9/11/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Revision :	A
First Issue :	/ /	Type :	PURCHASED PARTS
Previous Run :	34875	Material :	
Written By :		Due Date :	9/26/2008
Checked & Approved By :		Qty:	100 ³⁰ Um: Each
Comment :	Est. A: 01.05.04 New Issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: 7144

a) Description: Alluminum billet

b) 7.750" x 8.250" x 2.50" thick

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Grain direction along 7.750" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

C208/09/11

(50)

2.0	D6101007P	7075-T7351 8.25X7.75X2.5
-----	-----------	--------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)
7075-T7351 8.25X7.75X2.5

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

Ref 10/10

(50)

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6101

508/10/15 *(150)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/11/2008 8:36:44 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET

Job Number: 41960

Part Number: D6101007

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SNC

12/8/14/14

J.P. 08/10/15

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/16 J.P.

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 8.10.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

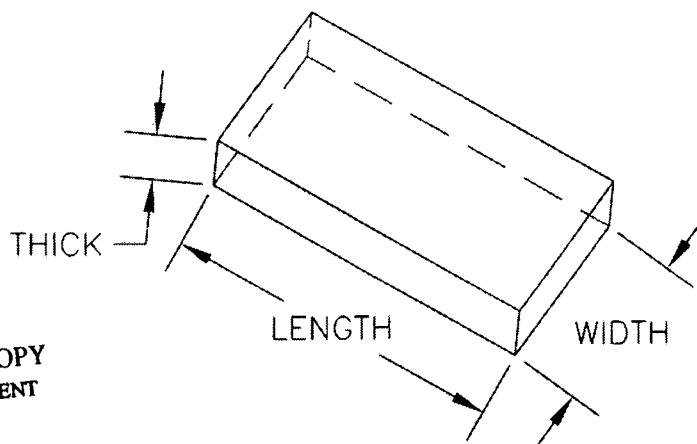


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>JS</i>	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23 *CH*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 411690



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

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SHIP TO:

A M CASTLE & CO
3400 NO. WOLF ROAD
FRANKLIN PARK, IL 60131

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215

Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number

4122744

SOLD TO:

AM CASTLE & CO
3400 NO. WOLF ROAD
FRANKLIN PARK, IL 60131

CUSTOMER PO NUMBER:

01-42198

WORK PACKAGE:

CUSTOMER PART NUMBER:

6879 A97075-60

SHIP RUN/LOAD ID:

101230/11

GOV'T CONTRACT NUMBER:

KAISER ORDER NO:

1061984

LINE ITEM:

1

SHIP DATE:

28-FEB-2008

ALLOY:

7075

CLAD:

BARE

TEMPER:

T7351

PRODUCT DESCRIPTION:

MILL FINISH PLATE

WEIGHT SHIPPED:

3596 LB

QUANTITY:

2 PCS EST.

B/L NUMBER:

2016662

GAUGE:

2.5000 IN

WIDTH:

48.500 IN

LENGTH:

144.500 IN

Certified Specifications

AMS 4078/RevG
ASTM B 209/Rev07
BSS 7055/RevA
DPS 4.713/RevAH
GSS16100/RevG

AMS-QQ-A-250/12
ASTM B 594/Rev06
CMMP 025/RevR
EAC MS1011/RevE
MMS 159/RevN

AMS-STD-2154
BAC 5439/RevH
CSTI 006/RevC
GAMPS 9101/RevB
PS 21211/RevK

Test Code: 4297

Test Results

Lot: 436539A1 Cast 149

Drop 39

Ingot 4

(ASTM E8/B557)

Tensile: Temper
T7351

Dir / # Tests
LT / 2 (Min:Max)

Ultimate KSI (MPA)
71.0 : 71.5
(490 : 493)

Yield KSI (MPA)
59.6 : 61.2
(411 : 422)

Elongation %
10.3 : 10.6

(ASTM E1004)

Conductivity %IACS :
(MS/M) :

41.1 Min
23.8 Min

41.5 Max
24.1 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.10	0.22	1.5	0.02	2.5	0.20	5.7	0.03	0.01	0.01	TOT 0.03

CASTLE METALS CORP.

DATE RCVD

IAC

APPROVED BY

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4122744

Lot: 436673A8 Cast 149 Drop 38 Ingot 3

(ASTM E8/B557)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	71.0 : 71.3 (490 : 492)	59.8 : 60.0 (412 : 414)	10.4 : 10.4

(ASTM E1004)

Conductivity %IACS :	41.0 Min	41.2 Max
(MS/M) :	23.8 Min	23.9 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.10	0.22	1.4	0.02	2.5	0.21	5.8	0.02	0.01	0.01	TOT 0.03

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075 MIN	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	EACH	0.05
MAX	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

TEST NOTES

Metal represented by this test report was immersion
ultrasonically tested from one side and meets the Class A
and Class B requirements of all specifications referenced
on this test report.

CERTIFICATION

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED IN THE U.S.A OR CANADA AND MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULANT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR



**KAISER
ALUMINUM****CERTIFIED TEST REPORT**

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

Serial Number .
4122744

Lot: 436673A8 Cast 149 Drop 38 Ingot 3

(ASTM E8/B557)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	71.0 : 71.3 (490 : 492)	59.8 : 60.0 (412 : 414)	10.4 : 10.4

(ASTM E1004)

Conductivity %IACS :	41.0 Min	41.2 Max
(MS/M) :	23.8 Min	23.9 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.10	0.22	1.4	0.02	2.5	0.21	5.8	0.02	0.01	0.01	TOT 0.03

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075 MIN	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	EACH	0.05
MAX	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

TEST NOTES

Metal represented by this test report was immersion
ultrasonically tested from one side and meets the Class A
and Class B requirements of all specifications referenced
on this test report.

CERTIFICATION

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BILL POYNOR, LABORATORIES SUPERVISOR



SHIP TO:
A M CASTLE & CO
3400 NO. WOLF ROAD
FRANKLIN PARK, IL 60131

**KAISER
ALUMINUM**

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4122744

SOLD TO:
AM CASTLE & CO
3400 NO. WOLF ROAD
FRANKLIN PARK, IL 60131

CUSTOMER PO NUMBER: 01-42198		WORK PACKAGE:	CUSTOMER PART NUMBER: 6879 A97075-80		SHIP RUN/LOAD ID: 101230/11	GOV'T CONTRACT NUMBER:	
KAISER ORDER NO: 1061884	LINE ITEM: 1	SHIP DATE: 28-FEB-2008	ALLOY: 7075	CLAD: BARE	TEMPER: T7351	PRODUCT DESCRIPTION: MILL FINISH PLATE	
WEIGHT SHIPPED: 3596 LB	QUANTITY: 2 PCS EST.	B/L NUMBER: 2016662		GAUGE: 2.5000 IN		WIDTH: 48.500 IN	LENGTH: 144.500 IN

Certified Specifications

AMS 4078/RevG
ASTM B 209/Rev07
BSS 7055/RevA
DPS 4.713/RevAH
GSS16100/RevG

AMS-QQ-A-250/12
ASTM B 594/Rev06
CMMP 025/RevR
EAC MS1011/RevE
MMS 159/RevN

AMS-STD-2154
BAC 5439/RevH
CSTI 006/RevC
GAMPS 9101/RevB
PS 21211/RevK

Test Code: 4297

Test Results

Lot: 436539A1 Cast 149

Drop 39

Ingot 4

(ASTM E8/B557)

Tensile: Temper
T7351

Dir / # Tests
LT / 2 (Min:Max)

Ultimate KSI (MPA)
71.0 : 71.5
(490 : 493)

Yield KSI (MPA)
59.6 : 61.2
(411 : 422)

Elongation %
10.3 : 10.6

(ASTM E1004)

Conductivity %IACS :
(MS/M) :

41.1 Min
23.8 Min

41.5 Max
24.1 Max

(ASTM E1251)

Chemistry:
Actual

SI

FE

CU

MN

MG

CR

ZN

TI

V

ZR

OTHER

0.10

0.22

1.5

0.02

2.5

0.20

5.7

0.03

0.01

0.01

TOT

0.03

CASTLE METALS CORP.

DATE RCVD

3/4/08

IAC

6879

APPROVED BY

[Signature]